

Work Order ID 144555

Thursday, April 21, 2016 8:38:35 AM

144555

Page 1

Item ID: D2992-1

Revision ID:

Item Name: Doubler

Start Date: 4/21/2016 Start Qty: 5.00

Required Date: 5/6/2016 Req'd Qty: 5.00

Reference:

Cut to send to FDC for doors.
**5* 16350.*
5

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2992	B								

100

0.00

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D2992

Dwg Rev: B

Prog Rev: B

2-Debur if necessary

0.00

(5)

De 16/04/25

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

(5)

De 16/04/25

120

QC8- Inspect parts - second check

0.00

120

QC

Quality Control

Memo

0.00

(5)

DAS
38
9-89

APR 25 2016

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Item ID: D2992-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Doubler
 Start Date: 4/21/2016 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 5/6/2016 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							<i>5x of all 16/04/25</i>
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							<i>(5)</i> DAS 38 9-89 APR 26 2016
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <i>STOCK</i> Memo	0.00 0.00							<i>5</i> APR 27 2016 DAS 6 9-89

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Item ID: D2992-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 4/21/2016 Start Qty: 5.00

5

Cust Item ID:

Required Date: 5/6/2016 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MLJ APR 27 2016MLJ APR 27 2016

Picklist Print

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Parent Item: D2992-1

D2992-1

Parent Item Name: Doubler

Start Date: 4/21/2016

Required Date: 5/6/2016

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP B02.03.06 Added dwg Rev.BNG
IPP Rev:C 08-04-22 now on water jet DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.040		Purchased		No		100	sf	68.1076	0.0903	0.475263			

M5052H32S 040

2016/04/25

5052-H32 .040 Sheet

Location

Loc Qty

Loc Code

MAT023

68.1076102

m129530

4.0984

m132546

1.4955262

m133550

24.7

m1342217

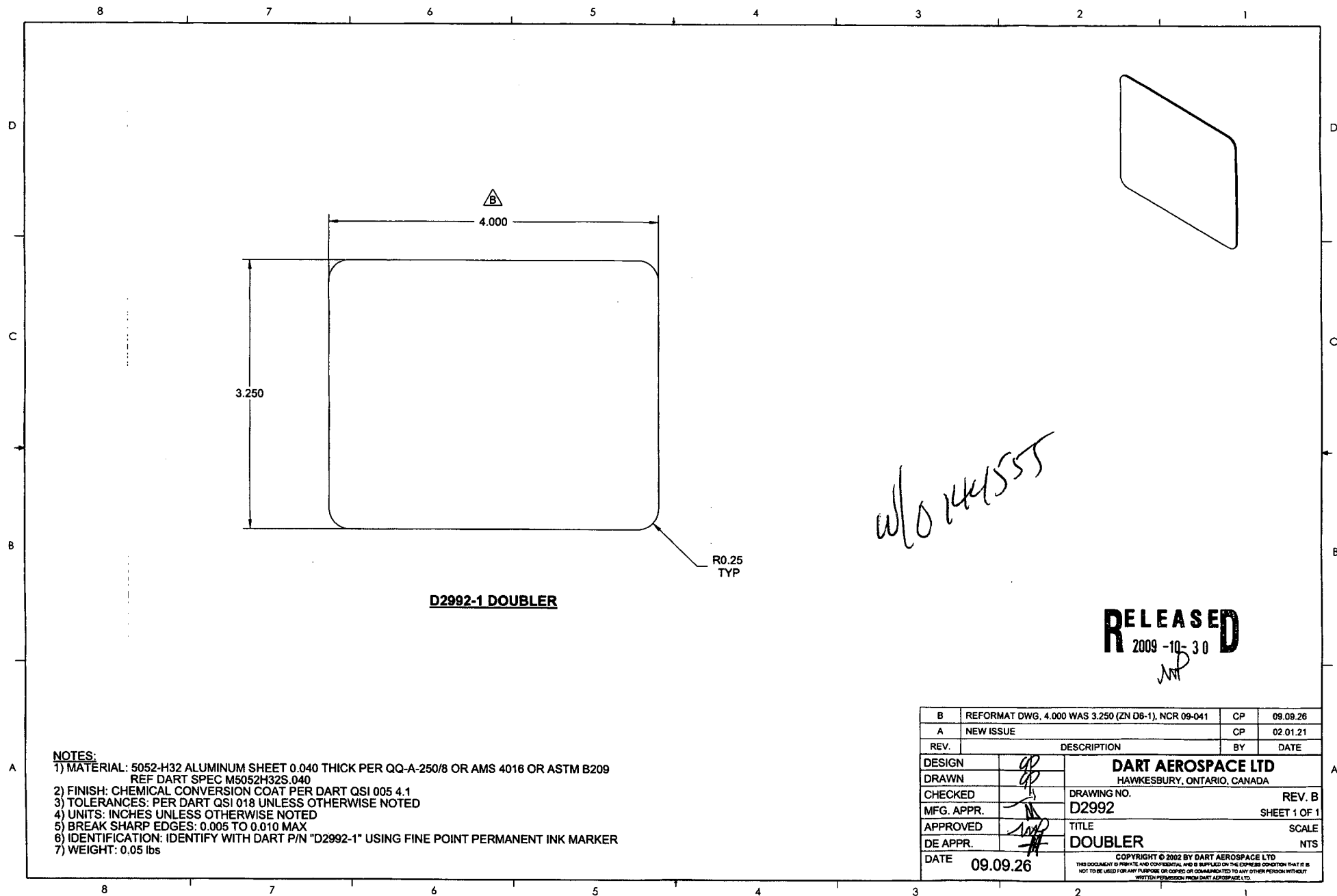
5.813684

m134617

32

FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	08.04.30	New Issue	KJ/DD	



B	REFORMAT DWG, 4.000 WAS 3.250 (ZN D8-1), NCR 09-041	CP	09.09.26
A	NEW ISSUE	CP	02.01.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.09.26		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. B
D2992	TITLE	SHEET 1 OF 1
DOUBLER	SCALE	NTS
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